Work Orde Wednesday, Nove	r ID 64065 ember 24, 2010 8:32:38 AM	•								Page 1
Revision ID: Item Name:	D3436-5 Bushing		Accept				S	etup Start Stop		#16 18 18 18 #16 18 18 18
Start Date: 1 Required Date: 1 Reference:	11/24/2010 Start Qty: 20 11/30/2010 Req'd Qty: 20			Cust Item I	D: 	_	D	un Star	+	8118 181 1781 188 <i>1</i>
	Process Plan:QC:	Date:	Tooling: SPC (Y/N):		nte: nte:		Ŋ	Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr Rev A								/	
100 Hardinge CNC Lathe	Hardinge CNC LA		0.00 0.00 vg D3436 , Deburr	/ (20	L		
QC Quality Control	QC2- Inspect parts Memo	off machine FAI/FAIB	0.00	/ (/			20)	Ø		
QC Quality Control	QC8- Inspect parts		0.00 B.A 110	1(1)			20	<u> </u>		

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C C	osed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Work Order ID 64065

Page 2

Wednesday, November 24, 2010 8:32:38 AM

Item ID:

D3436-5

Accept

Setup Start



Stop

Revision ID:

Bushing Item Name:

Start Date:

11/24/2010

Start Qty: 20.00

Required Date: 11/30/2010

Req'd Qty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

Qty

Stop

Reject



Date:

SPC (Y/N):

Set Up/

Date:

Tool # Plan

Code

Accept

Qty

Number Stamp

11/4/11 Co

Sequence ID/ Work Center ID

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location: LARF.

Run Hours

0.00

Memo

*****STOCK IN LARGE FAB*****

140

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

- 4	. oopaoc	Liu								•
W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·				*					
Part No		PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQA	\:	_ Date: _	
	R	esolution:	Disposition	1:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	IANCE	(NCR)		·		
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
									-	
				·						

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:32:42 AM

Work Order ID: 64065

Parent Item: D3436-5

Parent Item Name: Bushing



Start Date: 11/24/2010

Start Qty: 20.00

Required Date: 11/30/2010

Required Qty: 20.00

Comments:

IPP A□05.05.11□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.373W.049		Purchased	No			100	f	14.0000	0.1083	2.28	(1)	/1/(,//

4130 RD tube .373 x .049W

Loc Qty Loc Code Location MAT30 14 - 111329 14

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-		Frod Wgi	
						······································	-		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		_ Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
								1	
			1		ı	1		I	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	1,4065
Description: Bushing	Part Number:	D3436-5
Inspection Dwg: D3436 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST **First Article Prototype** X Actual **Drawing Method of** Comments **Tolerance** Accept Reject Inspection Dimension **Dimension** Vesu 1.26 +/-0.030 Ø0.38 +/-0.030 +/-0.010 0.049 4.6 **Prototype Approval:** N/A Audited by: Measured by: N/A Date: 11/01/11 Date: Date: Revised by Approv*e*d Date Change Rev

KJ/JLM 🖟

H-\FORMS\Qualit	Assurance\approved	QA\FAI revD

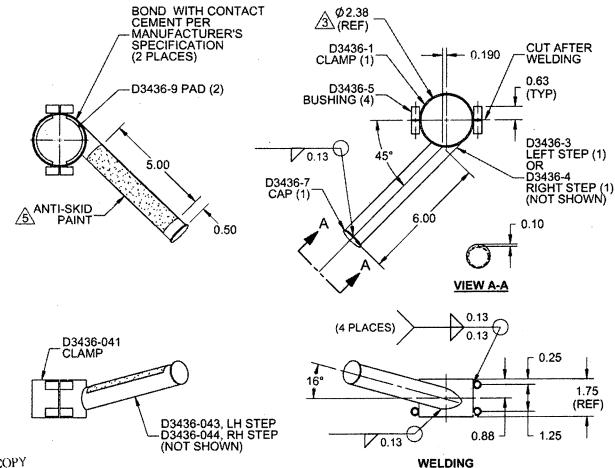
New Issue

05.07.07



DESIGN DRAWN BY MB		1	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	ED#	APPROVED #	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE	05.0)4.28	MAINTENANCE STEP	SCALE 1:4
Α	0	5.04.28	NEW ISSUE	

05.05.27



SHOP COPY **RETURN TO**

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

41065 1011-24

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
 2) WELD PER DART QSI 004
 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES

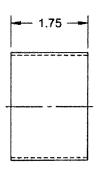
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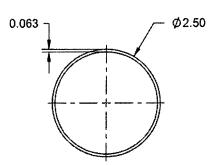
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED	drawing no. D3436	REV. A SHEET 2 OF 4			
DATE		TITLE	SCALE			
05.04.28		MAINTENANCE STEP	1:2			

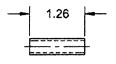
ulo 44065

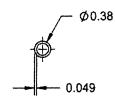




D3436-1 CLAMP

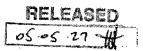
1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





/ D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)



D3436-1/ -5, GENERAL NOTES:

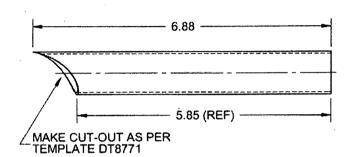
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

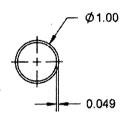
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4		
DATE		TITLE	SCALE		
05.0	4.28	MAINTENANCE STEP	1:2		

ulo 44045

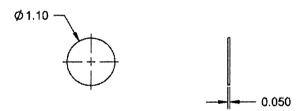




D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED 05-05.27

D3436-3/ -7, GENERAL NOTES:

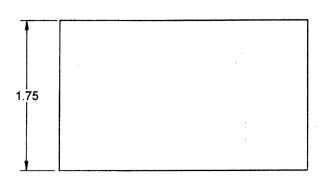
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

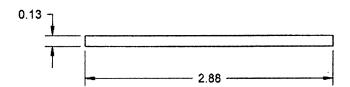
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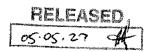


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED	APPROVED #	DRAWING NO. D3436	REV. A SHEET 4 OF 4		
DATE 05 (04.28	MAINTENANCE STEP	SCALE		

ulo 64068







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S.125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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